

Work Order ID 74830

October-11-11 7:06:55 AM

Must ship Friday Oct 14th

74830

Page 1

Item ID: D3510-041

Accept

N900040100

Setup

Start *NS1*

Revision ID:

Stop

NS2

Item Name: Skidtube Insert Assembly

Start Date: 10/11/11 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/14/11 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

✓

Date:

Tooling:

Date:

Run

Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3510

Rev C

100

100

Mori Seiki

Mori Seiki CNG Lathe Large

110

QC2- Inspect parts off machine FAI/FAIB

110

QC

Quality Control

Memo

Turn as per Dwg D3510 & Folio FA652
Ensure that DT8877A Plug fits in tube.

0.00

0.00

0.00

10

MM.L 11/10/11

1

2

PB

?

MM.L 11/10/11

W/O: 74830		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3510-041 PAR #: N/A Fault Category: Landing Gear / Mori NCR: Yes No DQA: S Date: 11/11/10
 Resolution: Rewire Disposition: Rewire QA: N/C Closed: S Date: 11/11/10

NCR: 11-059		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-10-12	100	cut the wrong length. I cut 30.436 and stated 30.750 R.C. operator error	S 051-042 11/10/13	Return left over part Back in to stock. QH +1	11-059 L 11/10/13	11/10/13	S 051-042 11/10/13	S 11/10/13
		Loss						

NOTE: Date & initial all entries

Work Order ID 74830

October-11-11 7:06:55 AM

74830

Page 2

Item ID: D3510-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube Insert Assembly

Stop

NS2

Start Date: 10/11/11 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/14/11 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

120

120

HAAS 1

HAAS CNC vertical machine #1

2-Deburr

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

B.A 11/11/01

1 0

Note: *-****,.250" dia holes are to be opened to finish size by skidtube dept, and
missing .266" dia hole is to be drilled by skid dept.*****

130

130

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

B.A 11/11/01

1 0

140

140

QC

Quality Control

QC8- Inspect parts - second check

0.00

R. u. u. 1

1 0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74830

October-11-11 7:06:55 AM

Shop Job. 2

74830

Page 3

Item ID: D3510-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube Insert Assembly

Stop

NS2

Start Date: 10/11/11 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/14/11 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

150

Skidtubes

Skidtubes

0.00

Tool ID

Tool #

Plan
Code

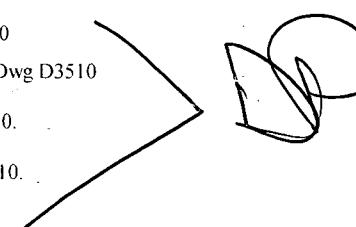
Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Memo 0.00
1-Drill L .266" Dia hole using DT8877B as per Dwg D3510
2-Counter bore wearplate holes as per Dwg d3510.
3-open wearplatre holes to .297 as per Dwg D3510.
4-Deburr



11-11-11

160

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

11-11-02 0

170

170

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

M-F 11/11/02

Memo 0.00

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 74830

October-11-11 7:06:55 AM

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Page 4

Item ID: D3510-041

Accept

N900040100

Setup Start

NS1

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Item Name: Skidtube Insert Assembly

Stop

NS2

Start Date: 10/11/11 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/14/11 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

180

QC3- Inspect Part Finish

180

QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

1 BL 11-11-2.

0.00

190

190

HandFinish

HandFinishing

0.00

0.00

1 BL 11-11-2.

200

200

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

11-11-02 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 74830

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Page 5

Item ID: D3510-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube Insert Assembly

Stop

NS2

Start Date: 10/11/11 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/14/11 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

210

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

PPP 75286

0.00

220

220

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/11/11 2011

11/11/02

MF
11-11-02

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

October-11-11 7:06:55 AM

Page 1

Work Order ID: 74830

Parent Item: D3510-041

Start Date: 10/11/11

Required Date: 10/14/11

Parent Item Name: Skidtube Insert Assembly

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-10-12 JLM
 IPP Rev:B ALES-1032 and ALS4-428 insert now used ECN 1036 DD
 IPP Rev:C Revised manufaturng steps for LG 08-09-29 Veriifed By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-225 Insert		Purchased	No			190	Each	1,852.0000	6	12			
				<u>Location</u>			<u>Loc Qty</u>				<u>6.</u>	<i>BR 11-11-2</i>	
				ST282	118696		1852						
					110768		62						
					118386		860						
					118966		930						
ALS4-428-165 Inserts		Purchased	No			190	Each	489.0000	2	4			
				<u>Location</u>			<u>Loc Qty</u>				<i>2.</i>	<i>BR 11-11-2</i>	
				FP			471						
					117769	/	471						
				FP-B			18						
					114172		18						
ALS7-1032-130 Insert		Purchased	No			190	Each	1,177.0000	2	4			
				<u>Location</u>			<u>Loc Qty</u>				<i>2.</i>	<i>BR 11-11-2.</i>	
				ST281			1000						
					118966	/	1000						
				ST282			177						
					117717		31						
					118386		146						
M6061T6T3.500W.375 6061-T6 RD Tube 3.50 X .375 W		Purchased	No			100	f	12.9631	2.55	5.3684211			
				<u>Location</u>			<u>Loc Qty</u>						
				MAT			12				<i>5.3684</i>	<i>M.M.L 11/10/11</i>	
					118071		12						
				MAT014			0.9631						
					117392		0.9631						

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	74830
Description: Skidtube Insert	Part Number:	D3510-041
Inspection Dwg: D3510	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.300	+/-0.010	3.301	✓		Vern	CNC-08
Ø2.950	+/-0.010	2.940	—		"	
Ø2.750	+/-0.010	2.747	✓		"	
R0.25 x 0.066	+/-0.010	0.25 x 0.066	✓			
15.00	+/-0.030	15.00	✓		tape	
0.063 x 45°	+/-0.010 x 0.5°	0.063 x 45°	—		Vern	CNC-08
0.125 x 45°	+/-0.010 x 0.5°	0.125 x 45°	—		"	
5.270	+/-0.010	5.277	✓		"	
3.265	+0.000/-0.010	3.258	✓		"	
30.50	+/-0.030	30.500	✓		tape	
9.515	+/-0.010	9.515	✓		Vern	CNC-02
6.875	+/-0.010	6.875	✓		"	"
13.750	+/-0.010	13.750	✓		tape	GA-08
1.600	+/-0.010	1.600	✓		H-6	31006
2.165	+/-0.010	2.165	✓		Vern	GA-01
6.735	+/-0.010					
2.981	+/-0.010					
2.434	+/-0.010					
1.036	+/-0.010					
Ø0.266	+0.006/-0.001	Ø0.266	✓		Vern	GA-01
Ø0.391	+/-0.010	Ø0.392	✓		"	"
Ø0.516 x 0.100	+/-0.010	Ø0.520 x 0.100	✓		"	"

Measured by:	MARY. C/B	Audited by:	EE	Prototype Approval:	N/A
Date:	11/10/11	Date:	11.11.11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.01	New Issue	KJ	MM

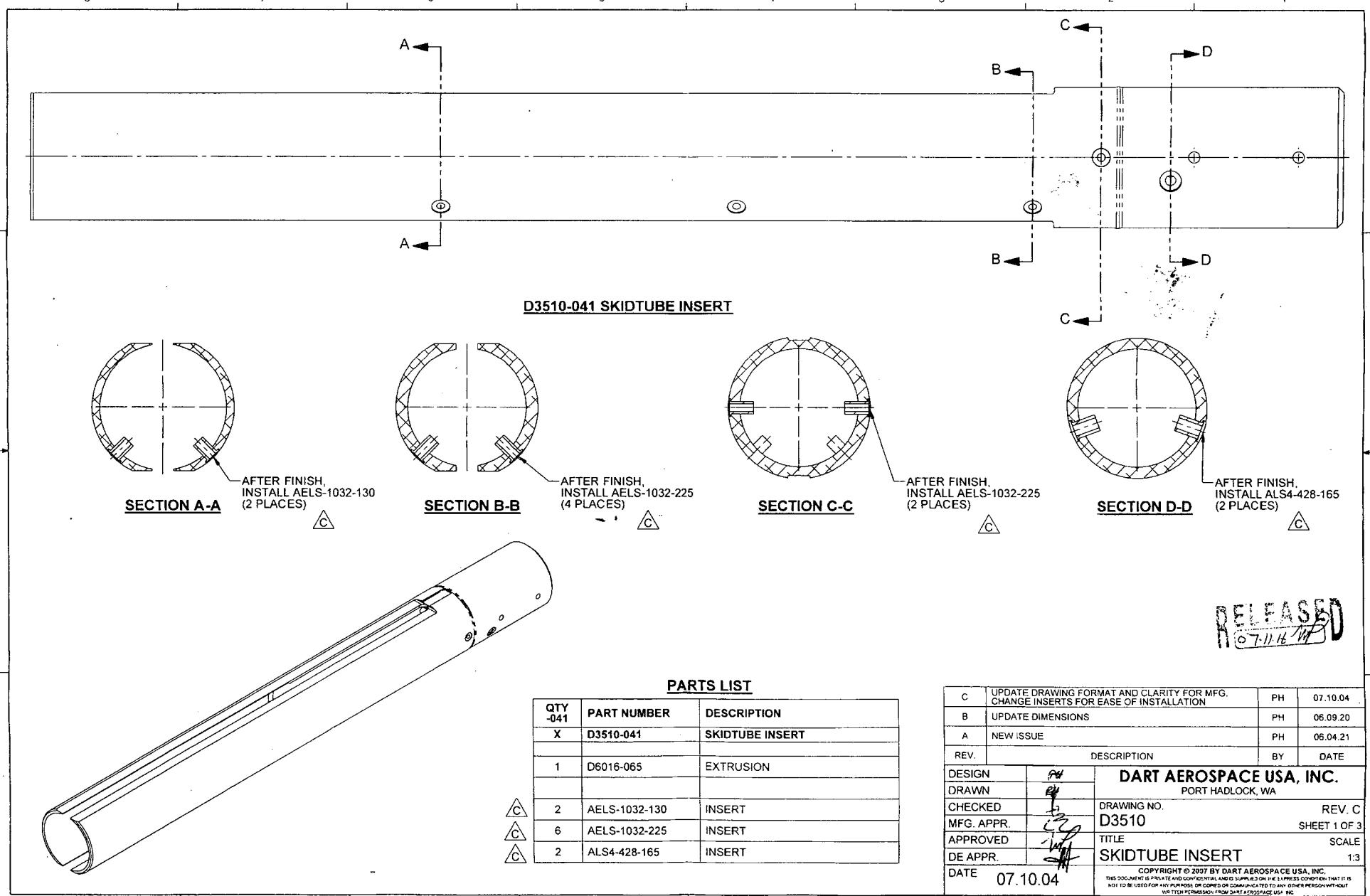
Dart Aerospace Ltd

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NOTE: Date & initial all entries



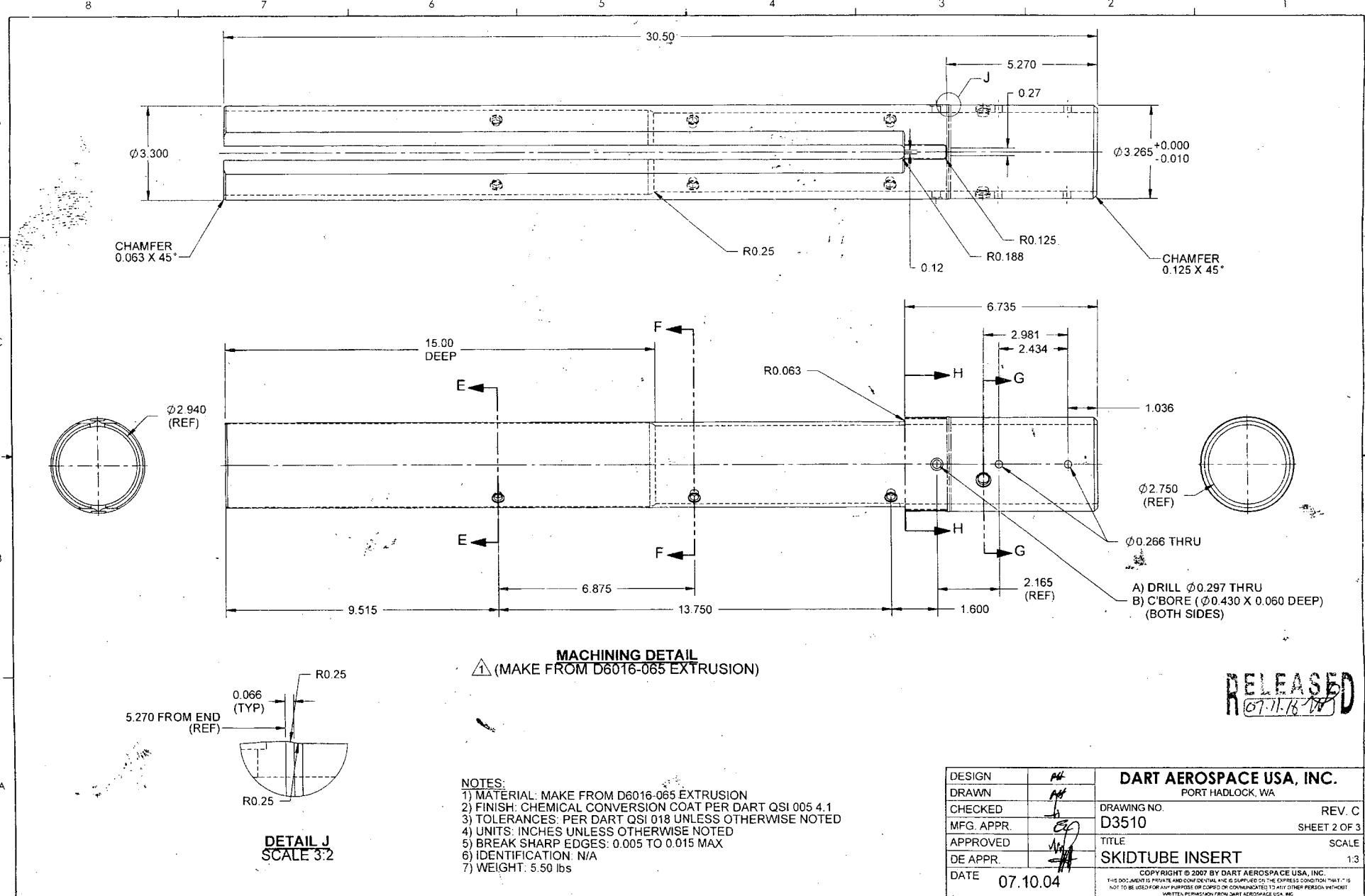
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NOTE

NOTES:
1) MATERIAL: MAKE FROM D6016-065 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 5.50 lbs

DETAIL J
SCALE 3:2

DESIGN	<u>44</u>	DART AEROSPACE USA, INC.	
DRAWN	<u>44</u>	PORT HADLOCK, WA	
CHECKED	<u>1</u>	DRAWING NO.	REV. C
MFG. APPR.	<u>EG</u>	D3510	SHEET 2 OF 3
APPROVED	<u>MJ</u>	TITLE	SCALE
DE APPR.	<u> </u>	SKIDTUBE INSERT	
DATE	07.10.04	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO OTHERS WITHOUT THE EXPRESS WRITTEN CONSENT OF DART AEROSPACE USA, INC.	

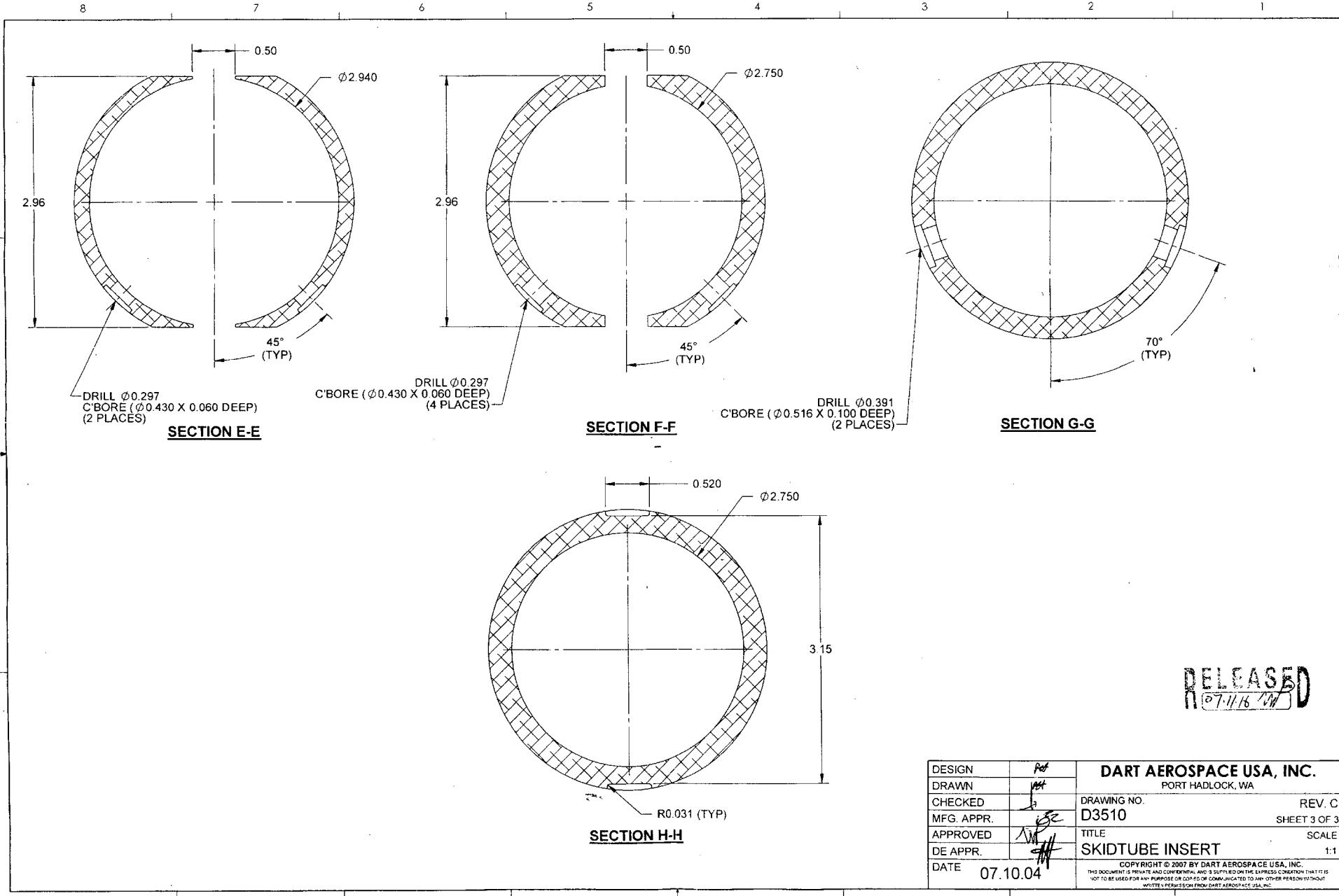
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